

Date: Monday, 7/9/2007 3:44:12 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : NUT PLATE
Job Number : 33434	
Estimate Number : 11262	
P.O. Number : <i>N/A</i>	Part Number : D3415041
This Issue : 7/9/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3415 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 30837	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 7/27/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: A 05.10.03 New issue KJ/JLM	
Est Rev:B Now on Waterjet 07-03-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0138 sf(s)/Unit Total : 0.2751 sf(s)

304/316 .063 Sheet

Batch: *m10873* *HB 07-07-27*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3415

Dwg Rev: *B*Prog Rev: *B**HB 07-07-27*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*HB 07-07-27*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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*carfers*
120

Comment: SECOND CHECK

En 07/07/30

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr *a.m 07.07.30*

2-C'sink as per Dwg D3415

*m10873**x20**S.A QC #5**inspect work to current step.**En 07/07/31 x19*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/07/30	#5	ADD A QC INSPECT WORK REQUIREMENT (STEP) AFTER STEP #5 before parts go to BUR BURCOAT.	EP	07/07/30			EP 07/07/30	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/09/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial. Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/11	# -	one plate was lost. Between step 4.0 to #5.1	OS/11/11	Qty 19 total	EP 07/09/11	EP 07/04/11	OS/11/11	EP 07/04/11
		Rel. Humware error (core issues)						

NOTE: Date & initial all entries

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Job Number: 33434

Part Number: D3415041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M105068



(20X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L: 07/08/03

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 07-08-09

20

8.0

MS21070L4

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut Plate

Pick:

Qty Part Number Description Batch

1 MS21070L4 Nut Plate

M103925

FF 07-08-09

20

9.0

MS206133C3-

MS20427 F 3-3 RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

RIVET

Batch:

~~M18855~~ M18855

FF 07-08-09

20

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut plate as per Dwg D3415

FF 07-08-13

20

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/08/14 (170)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/08/15 (19)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/08/13	#	Change Rivets MS206 1333 to MS20427F33 AS Per Drawing D345 and correct Drawing	See step #9			07/08/13 [Signature]	En 07/08/13	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.15

Job Completion



6 070815

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

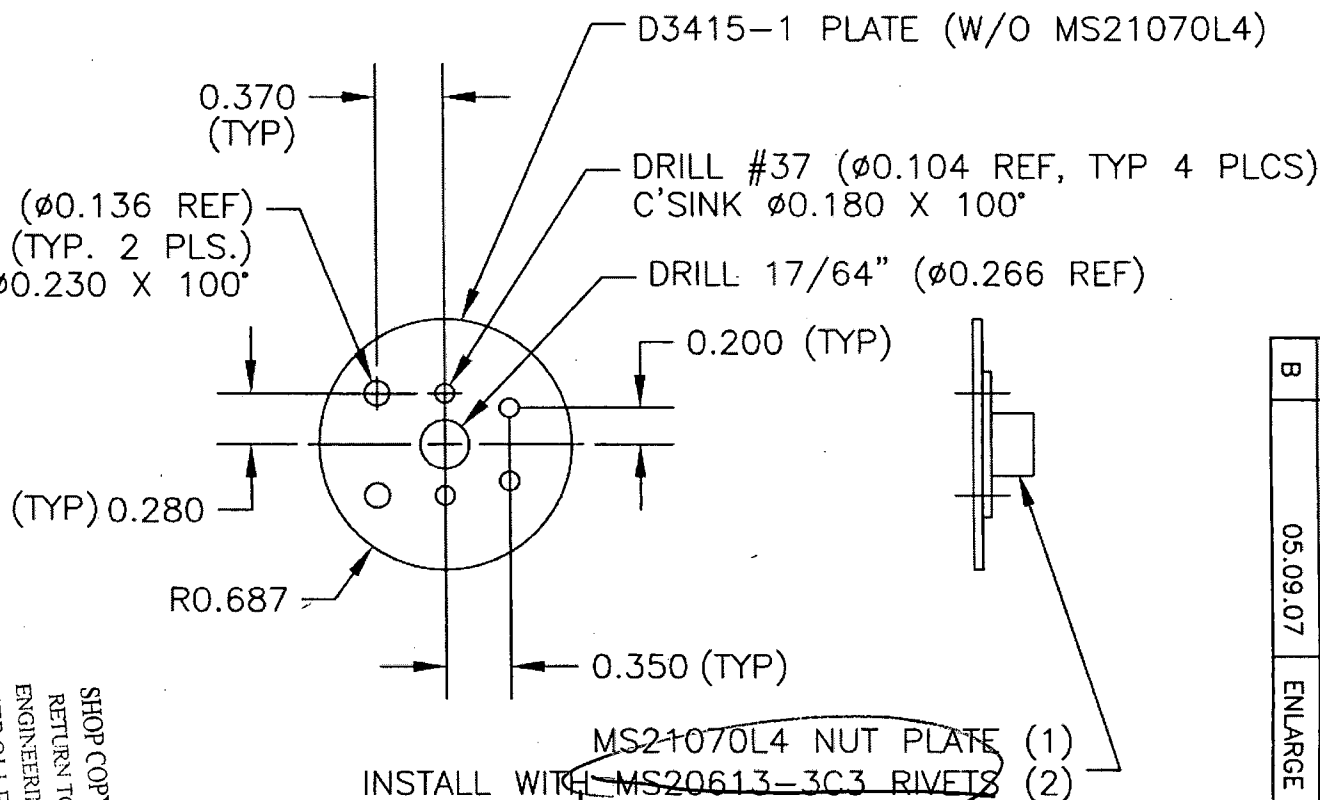
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CP	CP	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3415	SHEET 1 OF 1
DATE	TITLE	SCALE	
05.09.07	NUT PLATE	1:1	
A	05.03.16	NEW ISSUE	
B	05.09.07	ENLARGE ALL HOLES FOR POWDER COAT	



MS20427 F3-3

07.08.10 ROL OF OR

RELEASED
05.09.09-11

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *33434*

D3415-041 NUT PLATE

- 1) MATERIAL: AISI 304 SS SHEET, 0.063 THICK
(16 GAUGE, REF DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

